

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
22 December 2005 (22.12.2005)

PCT

(10) International Publication Number
WO 2005/120799 A1

(51) International Patent Classification⁷: **B29C 45/02**,
45/73, H01L 21/56

(21) International Application Number:
PCT/NL2005/000421

(22) International Filing Date: 9 June 2005 (09.06.2005)

(25) Filing Language: Dutch

(26) Publication Language: English

(30) Priority Data:
1026407 11 June 2004 (11.06.2004) NL

(71) Applicant (for all designated States except US): **FICO
B.V.** [NL/NL]; Ratio 6, NL-6921 RW Duiven (NL).

(72) Inventor; and

(75) Inventor/Applicant (for US only): **VENROOIJ, Jo-
hannes, Lambertus, Gerardus, Maria** [NL/NL];
Brederode 18, NL-6922 BM Duiven (NL).

(74) Agent: **VAN DEN HEUVEL, Henricus, Theodorus**;
Patentwerk B.V., P.O. Box 1514, NL-5200 BN 's-Herto-
genbosch (NL).

(81) Designated States (unless otherwise indicated, for every
kind of national protection available): AE, AG, AL, AM,
AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN,
CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI,
GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE,
KG, KM, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA,
MD, MG, MK, MN, MW, MX, MZ, NA, NG, NI, NO, NZ,
OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL,
SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC,
VN, YU, ZA, ZM, ZW.

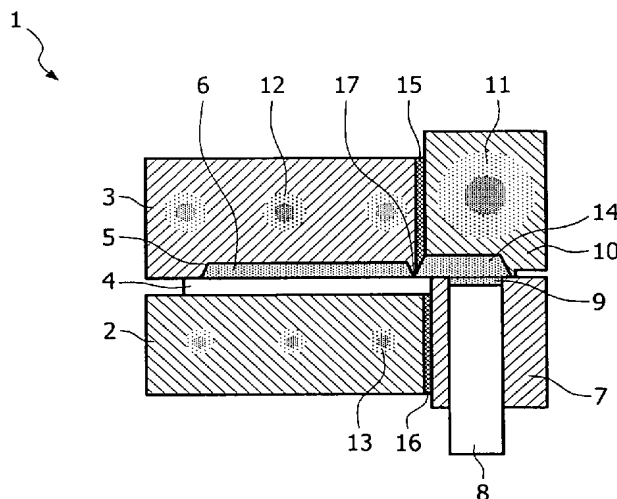
(84) Designated States (unless otherwise indicated, for every
kind of regional protection available): ARIPO (BW, GH,
GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM,
ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM),
European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI,
FR, GB, GR, HU, IE, IS, IT, LT, LU, MC, NL, PL, PT, RO,
SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN,
GQ, GW, ML, MR, NE, SN, TD, TG).

Declaration under Rule 4.17:

— as to applicant's entitlement to apply for and be granted
a patent (Rule 4.17(ii)) for the following designations AE,
AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ,

[Continued on next page]

(54) Title: METHOD AND DEVICE FOR CONTROLLABLE ENCAPSULATION OF ELECTRONIC COMPONENTS



(57) Abstract: The invention relates to a method for encapsulating electronic components mounted on a carrier, comprising the processing steps of: A) heating encapsulating material, B) displacing the encapsulating material to a mould cavity, C) filling the mould cavity, and D) curing the encapsulating material in the mould cavity. Whereby the temperature regulation of the encapsulating material takes place during separate sections of the path covered by the encapsulating material by creating different temperature zones at least partially separated from each other thermally by means of at least one temperature barrier (15, 16). The invention also relates to a device for encapsulating electronic components mounted on a carrier.

WO 2005/120799 A1



CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NG, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, UZ, VC, VN, YU, ZA, ZM, ZW, ARIPO patent (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB,

GR, HU, IE, IS, IT, LT, LU, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG)

Published:

— with international search report

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

Method and device for controllable encapsulation of electronic components

The invention relates to a method for encapsulating electronic components mounted on a carrier as according to the preamble of claim 1. The invention also relates to a device
5 for encapsulating electronic components mounted on a carrier as according to the preamble of claim 9.

In the encapsulation of electronic components, more particularly the encapsulation of semiconductors mounted on a carrier (such as for instance a lead frame), use is made of
10 the so-called "transfer moulding process". The carrier with electronic components is herein clamped between two mould parts such that mould cavities are defined around the components for encapsulating. Liquid encapsulating material is then introduced into these mould cavities and, after at least partial curing of which the mould parts are moved apart and the carrier with encapsulated electronic components is removed. The
15 feed of encapsulating material takes place by means of one or more plungers with which pressure can be exerted on a supply of encapsulating material provided for this purpose. The plunger is displaceable in a housing into which the not yet liquid encapsulating material is also carried. The encapsulating material is usually placed in the mould in the form of a pellet or in the form of a package enclosed with foil material. The
20 encapsulating material normally consists of a thermocuring epoxy or resin which incorporates a filler. The plunger exerts a pressure on the encapsulating material which is simultaneously heated, as a result of which heating the encapsulating material becomes liquid. As a response to the pressure applied by the plunger, the liquid encapsulating material flows to the heated mould cavity and fills it with encapsulating
25 material. During this displacement of the encapsulating material this material is heated, whereafter it cures thermally (as a result of cross-linking) in the heated mould cavity. This method functions, but the duration of the processing cycle is long and the quality of the encapsulating process is not always readily controllable.

30 The Japanese patent 62 039215 describes a method for encapsulating products with resin. A mould for use herein is provided with mould cavities, which mould cavities have a lower temperature during the encapsulation than the feed channels and a plunger opening from which the encapsulating material is supplied. Arranged for this purpose in

an encapsulating device are different heating elements which can operate independently of each other at different temperature levels.

5 The object of the present invention is to provide a method and a device for an improved controllable encapsulation of electronic components and to improve the quality of such an encapsulation.

10 The present invention provides for this purpose a method as according to claim 1. The temperature regulation can relate to both heating and cooling of the encapsulating material. When the mould cavity is filled with encapsulating material, it is at least partially filled with encapsulating material, but it is usual for the mould cavity to be completely filled with encapsulating material. The method steps A) to D) are normally performed in alphabetical order. An important advantage of the method according to the invention is that the regulating options in respect of the temperature conditions to which
15 the encapsulating material is exposed during the different stages of the encapsulating process become better controllable, with the result that the behaviour of the encapsulating material also becomes more readily controllable. The viscosity of the material during critical phases of the encapsulating process, the location at which curing begins and the curing speed can for instance thus become precisely controllable.
20 Precisely because there is now at least one temperature barrier present, it is possible to realize a considerable temperature gradient between different sections. It is possible for the temperature of the encapsulating material to be higher, or conversely lower, during processing step A) than the temperature of the encapsulating material in the mould cavity.

25 An example will first be given of what the possible advantages can be of initially heating the encapsulating material more strongly and subsequently heating the encapsulating material less strongly (in the mould cavity). This variation in the temperature progression of the encapsulating material during moulding makes it
30 possible to optimize the process conditions for melting the encapsulating material, displacing the encapsulating material to the mould cavity and filling the mould cavity. This effect can be obtained particularly by means of the presence of at least one temperature barrier, whereby a comparatively considerable temperature difference can be created over a limited distance; in the absence of such a temperature barrier only

uniform temperature transitions can be obtained due to temperature conduction, these transitions moreover remaining relatively limited. It is thus precisely the presence of at least one temperature barrier which makes it possible to realize the advantages according to the present invention to the fullest extent. A fast melt of the encapsulating material can thus be obtained by already heating the encapsulating material to relatively high temperature during processing step A), and the melted encapsulating material at relatively high temperature can be displaced more rapidly than heretofore. The curing of the encapsulating material will also begin sooner than in the prior art, and the curing will also take place more rapidly. The encapsulating material will also be more easily displaceable from the feed means to the mould cavity since it is also less viscous at a higher temperature than at a lower temperature, at least shortly after this high temperature has been reached. The increased degree of fluidity of the encapsulating material will also still be present during filling of the mould cavity, whereby the risk of damage to the electronic component for encapsulating and the associated connections (for instance wire sweep) is reduced. Once the encapsulating material is present in the mould cavity, the temperature thereof will possibly fall back to a lower level. The heating means of relatively small capacity connecting for this purpose onto the mould cavity (or even the absence of heating means or the presence of cooling means) also provide advantages. The temperature load on the electronic component and the carrier can thus be smaller than if the prior art method were applied. This is all the more interesting now that more and more use is being made of encapsulating materials with less environmental impact ("green compounds") which must generally be processed at a higher temperature than the conventional encapsulating materials and, in the case of conventional encapsulation, can result in thermal damage to the components for encapsulating and/or carrier (parts). An obvious example hereof is the temperature sensitivity of tin solder present in some circumstances in the carrier and/or component. In a possible variant, the encapsulating material exceeds 140EC during processing step A), more preferably the encapsulating material exceeds 150EC, 160EC, 170EC or 180EC during processing step A).

30

A second example shows what the possible advantages can be of initially heating the encapsulating material less strongly and subsequently heating the encapsulating material to higher temperatures (in the mould cavity). In order to accelerate curing of the

encapsulating material (and thus shorten a processing cycle), it is desirable to minimize the residence time of the component enclosed with encapsulating material in a mould cavity. Since curing of encapsulating material normally takes place more rapidly at a higher temperature than at a lower temperature, curing can be optimized by heating the encapsulating material to the maximum possible temperature. The consequence hereof is that an encapsulated electronic component can be removed from an encapsulating device sooner than according to the prior art.

In a preferred variant, the encapsulating material is actively cooled prior to the start of processing step A) in a device for encapsulating electronic components mounted on a carrier. The starting situation of the encapsulating material prior to the beginning of the encapsulating process can thus be standardized, and a very controlled melting of a pellet of encapsulating material can for instance be obtained by urging such a pellet against a heated melting space (also referred to as the cull bar). The risk of contamination of the plunger housing (sleeve) in which a pellet is usually received is also prevented here.

In addition to the controlled creation of different temperature regimes at determined locations during a moulding process, it is also possible to regulate the temperature dynamically. This means that the temperature at a determined location undergoes controlled changes in time. A particular component of an encapsulating device can thus be heated to above a determined (initiation) temperature to cause a (curing) process to begin and, after this temperature has been reached, to cool the component (or allow the temperature thereof to fall passively) so as to limit for instance the chance of loss of quality of the materials for processing and/or the encapsulating device.

The encapsulating material can be heated during processing step A) by conduction, for instance by urging it against a heated surface. With the use of a plunger with which a body of encapsulating material is placed under pressure, it is possible for a pellet to be heated only by urging the body of encapsulating material against a cull bar, although it is also possible for optionally additional heat to be transmitted by the sleeve and/or the plunger. The advantage of urging a pellet against a cull bar such that it melts only on the side remote from the plunger is that this reduces the problem of leakage of encapsulating material between the plunger and the sleeve.

As an alternative to heating through conduction or in combination with the conductive heating of the encapsulating material, this latter can also be heated by radiation during processing step A). Examples hereof are, among others, induction, RF, ultrasonic or other contactless heating types. The local heating capacity can thus be further increased without this resulting in local overheating of the encapsulating material. A further advantage is that a uniform heating-through of the encapsulating material can be obtained with radiation. It will be apparent that the encapsulating material can also be heated in the mould cavity during processing step D) by conduction and/or radiation.

As already stated above, it is not necessary in determined conditions to heat the encapsulating material still further during processing step D). It is possible to allow the mould cavity to act in wholly passive manner in respect of temperature regulation, but it is also possible to envisage the mould cavity being actively cooled.

The invention also provides a device for encapsulating electronic components mounted on a carrier as according to claim 9. The feed means should be understood to mean not only a plunger with sleeve; the feed path of the plunger to the mould cavity also forms part of the feed means. As described above, a thermal separation of individual parts of an encapsulating device increases the possibilities of far-reaching control of the encapsulating process, with all the advantages this entails. The thermal separation can for instance be obtained by arranging a thermal insulating material between the feed means and the mould cavity and/or by arranging therebetween a recess separating the feed means and the mould cavity at least partially from each other such that the conduction of heat from the feed means to the mould cavity is at least considerably impeded. Ambient air can be present in the recess or an insulator can be placed therein. The form of the recess can be slot-like, but may also have any other desired form provided it functions to impede heat conduction. The thermal separation can be located between the feed means and the mould cavity and/or in at least one mould part.

The encapsulating device is preferably provided with a plurality of independently controllable temperature-regulating means. Such temperature-regulating means can be situated inter alia at or in the following locations of the encapsulating device: the plunger, the sleeve, the cull bar connecting onto the sleeve, the upper mould part or individual segments of the upper mould part and/or the lower mould part or individual

segments of the lower mould part. The control of the temperature-regulating means can be adapted such that the temperature-regulating means can control the temperature in a dynamic manner; that is, the temperature at a specific location in the device is changeable in time. It is noted here that it is possible for the opposite mould parts from which a mould cavity is assembled to have differing temperatures during use. It is thus possible to choose to give a mould part which is separated from the encapsulating material by the carrier a lower temperature than the mould part which comes into contact with the encapsulating material. As further elucidation of separate heating of different segments of the upper mould part and/or the lower mould part, it is for instance possible, subject to the local conditions (whether or not encapsulating material and/or carrier material is present locally), to heat or cool particular segments to a greater or lesser extent in order to thus create, in combination with one or more temperature barriers, different temperature zones in a mould part. The temperature-regulating means will generally be formed in practice by heating means, although they can also be cooling means.

An effective and structurally simple method of heating can be obtained by heating means with an electrical resistance. Such a resistance heating can be embodied as a heating rod embedded in a conductive thermal material or a flat (optionally flexible) heating element (also referred to as a heating map). Optionally in combination with a heating using an electrical resistance, use can also be made of temperature-regulating means in the form of a radiation source and/or other contactless heating techniques. Possible heating sources have already been listed above. Under specific conditions it is also possible to opt for embodying the mould cavity (optionally on one side) without heating means, or to even provide it with cooling means. For the advantages hereof reference is made to the above description relating to the method according to the present invention. The temperature-regulating means can be controlled by an active control, whereby it also becomes possible to control the temperature-regulating means in time. A dynamic temperature regulation can thus also be obtained locally.

In a preferred embodiment, the feed means for encapsulating material comprise a shield plate, which shield plate lies at a position directed toward the active side of the plunger and which shield plate is provided with independently controllable temperature-regulating means. Such a shield plate is also referred to as a cull plate. A body of

encapsulating material that has not yet been made liquid can be made liquid locally by being urged against such a shield plate, provided the plate is sufficiently heated.

The present invention will be further elucidated on the basis of the non-limitative exemplary embodiments shown in the following figures. Herein:

- 5 figure 1 shows a view of a cross-section through a schematically represented encapsulating device according to the invention,
- figure 2 shows a view of a cross-section through a schematically represented alternative embodiment variant of an encapsulating device according to the invention,
- figure 3 shows a view of a cross-section through a schematically represented second
- 10 alternative embodiment variant of an encapsulating device according to the invention,
- figure 4A shows a view of a detail of yet another embodiment variant of an encapsulating device according to the invention,
- figure 4B is a perspective view of a component of the encapsulating device shown in figure 4A, and
- 15 figure 5 shows a view of a part of yet another encapsulating device according to the invention during initiation of the encapsulating process.

Figure 1 shows a schematically represented encapsulating device 1 with a lower mould part 2 and an upper mould part 3 displaceable relative thereto. Clamped between mould

20 parts 2, 3 is a carrier 4 on which is mounted an electronic component which is not visible in this figure. Left clear in upper mould part 3 is a mould cavity 5 in which a housing 6 encasing the electronic component is formed. Lower mould part 2 is also provided with a sleeve 7 in which a plunger 8 is displaceable. Plunger 8 urges a pellet of encapsulating material, only a small remaining part 9 of which is still visible in this

25 figure, against a cull bar 10 which forms part of upper mould part 3. Shown schematically is that the temperature 11 of cull bar 10 is higher than the temperature 12 of upper mould part 3, which is in turn higher than the temperature 13 of lower mould part 2. Sleeve 7 is possibly wholly unheated. By urging a pellet of encapsulating material 9 against the heated cull bar 10 the encapsulating material will melt locally in

30 an intermediate space 14. From this intermediate space 14 the liquid encapsulating material flows through a gate 15 to mould cavity 5. Since the temperature management in encapsulating device 1 requires that cull bar 10 is hotter than mould parts 2, 3, respective thermal insulation elements 15, 16 are arranged between cull bar 10 and

upper mould part 3, and also between sleeve 7 and lower mould part 3 in order to limit the heat transmission to mould parts 2, 3.

Figure 2 likewise shows a schematically represented encapsulating device 20 which greatly resembles the encapsulating device shown in figure 1. In this encapsulating device 20 no heating is provided in a lower mould part 21 (including a sleeve 22). In an upper mould part 23 a heating 25 is provided only at the position of a cull bar 24. It will be apparent that in this encapsulating device the temperature of the encapsulating material will also decrease according to the present invention as soon as it is displaced out of an intermediate space 26 through a gate 27 to a mould cavity 28.

Figure 3 once again shows an encapsulating device 30 in which heating elements 31, 32 are now also arranged. Heating element 31 is placed in a cull bar 33 and consists of a transport pipe 34 to which an external heating 35 connects. The heat generated by the external heating 35 is carried by transport pipe 34 into cull bar 32. Similarly to heating element 31, heating element 32 is also provided with a transport pipe 36 and an external heating 37 so that close to a mould cavity 38 the heat generated by external heating 37 can be carried into an upper mould part 39. It is noted that pipes 34, 36 can also be used to cool the associated mould parts.

Figure 4A shows a part 40 of an upper mould part into which a mould cavity 41 is recessed. Received in mould half 40 is a mat 42 (see also figure 4B) with which the temperature of mould half 40 can be regulated. Mat 42 can be embodied as heating element, as cooling element or as a combination thereof. A mat 42 can likewise be embodied such that it defines different temperature zones during use.

Figure 5 shows a part of an encapsulating device 50 during the start of the encapsulating process. A pellet of encapsulating material 51 is urged by a plunger 52 against a cull bar 53 as according to arrow P1. Cull bar 53 is heated by the external heating 55 via a heat transport pipe 54. Also provided is a radiation source 56 with which the encapsulating material 51 is directly heated. Encapsulating material 51 melts as a result of the contact with cull bar 53 and the heat transfer on the top side resulting therefrom.

Claims

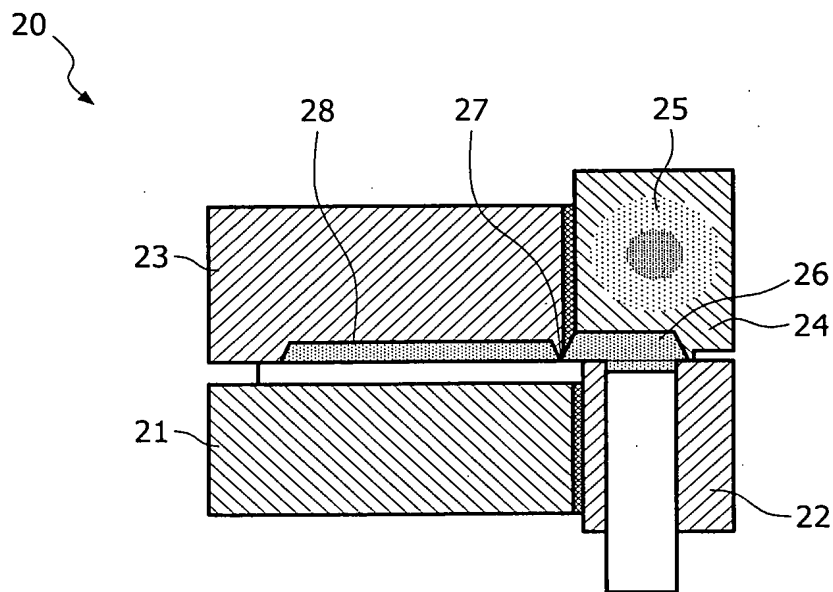
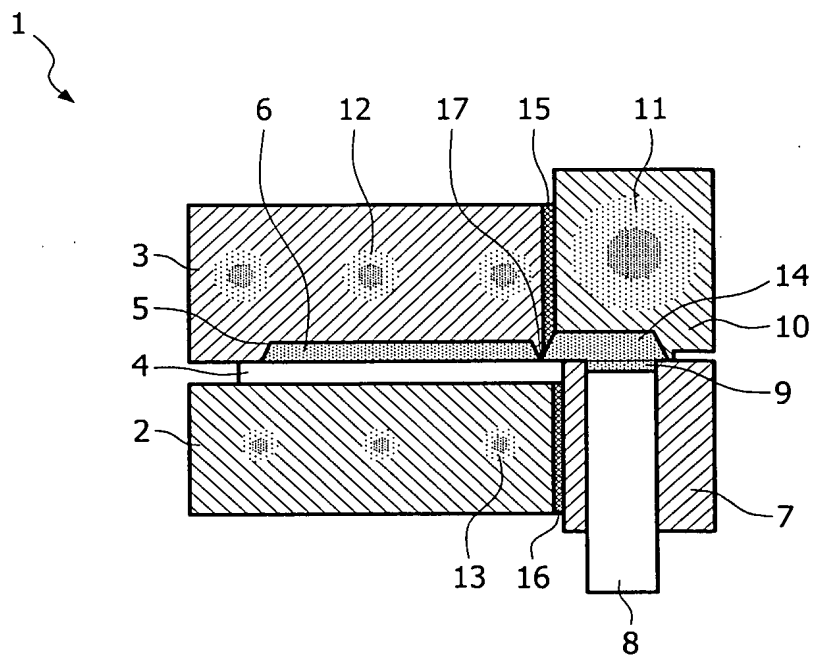
1. Method for encapsulating electronic components mounted on a carrier, comprising the processing steps of:
 - 5 A) heating encapsulating material such that it becomes liquid,
 - B) displacing the encapsulating material to a heated mould cavity enclosing the electronic component by exerting pressure on the liquid encapsulating material,
 - C) filling the mould cavity with encapsulating material, and
 - D) at least partially curing the encapsulating material in the mould cavity,
- 10 **characterized in that** temperature regulation of the encapsulating material takes place during separate sections of the path covered by the encapsulating material during the processing steps A) - C) by creating different temperature zones at least partially separated from each other thermally by means of at least one temperature barrier.
- 15 2. Method as claimed in claim 1, **characterized in that** the temperature regulation comprises of conditioned heating of the encapsulating material.
3. Method as claimed in claim 1 or 2, **characterized in that** the temperature of the encapsulating material is higher during processing step A) than the temperature of the encapsulating material in the mould cavity.
- 20 4. Method as claimed in claim 1 or 2, **characterized in that** the temperature of the encapsulating material is lower during processing step A) than the temperature of the encapsulating material in the mould cavity.
- 25 5. Method as claimed in any of the foregoing claims, **characterized in that** prior to the start of processing step A) the encapsulating material is actively cooled in a device for encapsulating electronic components mounted on a carrier.
- 30 6. Method as claimed in any of the foregoing claims, **characterized in that** the temperature of the path covered by the encapsulating material during processing steps A) - C) is regulated dynamically.

7. Method as claimed in any of the foregoing claims, **characterized in that** the encapsulating material is heated by radiation during processing step A).
8. Method as claimed in claim 7, **characterized in that** the encapsulating material
5 is actively cooled in the mould cavity during processing step D).
9. Device for encapsulating electronic components mounted on a carrier, comprising:
- mould parts which are displaceable relative to each other and which in a closed
10 position define at least one mould cavity for enclosing an electronic component, and which mould parts are provided with temperature-regulating means, and
 - feed means for liquid encapsulating material connecting onto the mould cavity and provided with at least one plunger, which feed means are provided with temperature-regulating means,
- 15 **characterized in that** the feed means for the encapsulating material and the mould cavity are at least partially separated from each other thermally.
10. Device as claimed in claim 9, **characterized in that** the thermal separation between the feed means and the mould cavity comprises at least one recess located
20 therebetween.
11. Device as claimed in claim 9 or 10, **characterized in that** the thermal separation comprises at least one recess incorporated in a mould part.
- 25 12. Device as claimed in any of the claims 9-11, **characterized in that** the temperature-regulating means co-acting with the mould parts can be controlled independently of the temperature-regulating means co-acting with the feed means.
- 30 13. Device as claimed in any of the claims 9-12, **characterized in that** a mould part is provided with a plurality of independently controllable temperature-regulating means.
14. Device as claimed in any of the claims 9-13, **characterized in that** the temperature-regulating means comprise heating means.

15. Device as claimed in any of the claims 9-14, **characterized in that** at least one of the temperature-regulating means comprises a radiation source.

5 16. Device as claimed in any of the claims 9-15, **characterized in that** the feed means for encapsulating material comprise a shield plate, which shield plate lies at a position directed toward the active side of the plunger and which shield plate is provided with independently controllable temperature-regulating means.

1/3



2/3

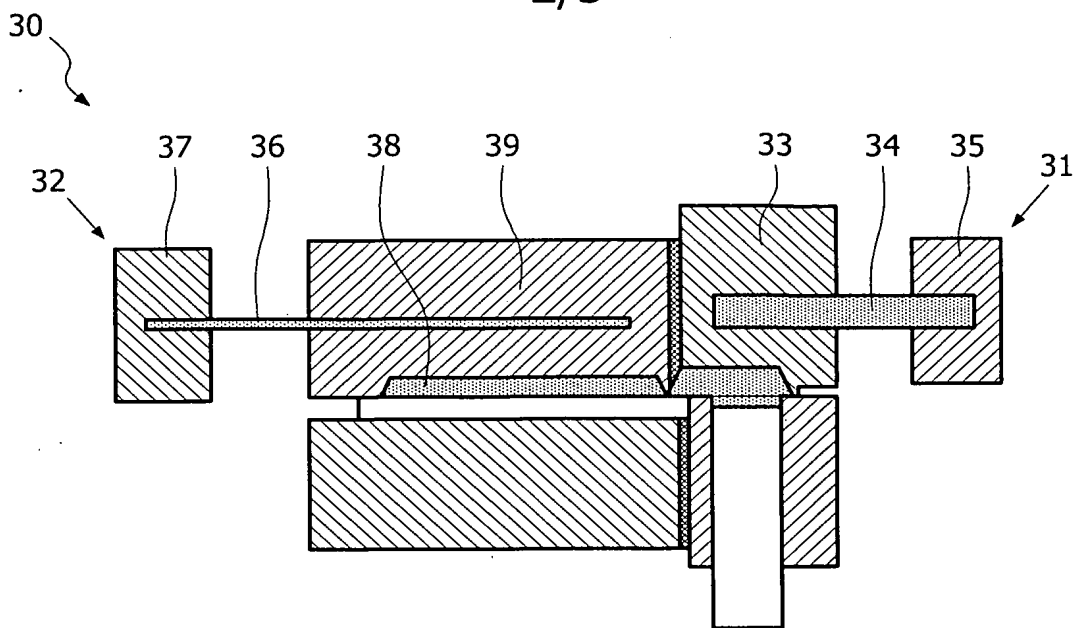


FIG. 3

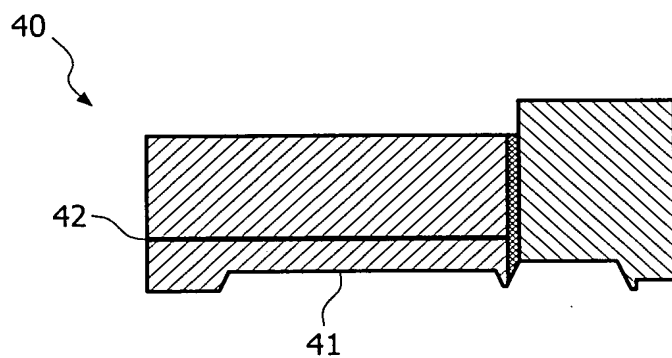


FIG. 4A

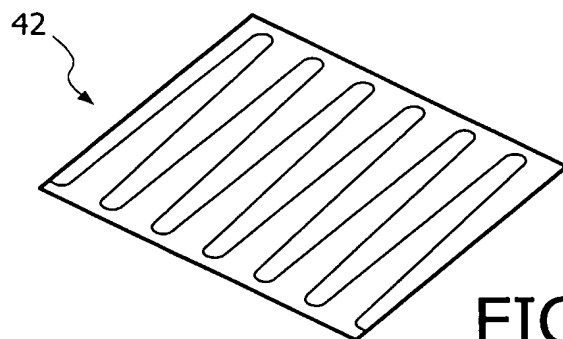


FIG. 4B

3/3

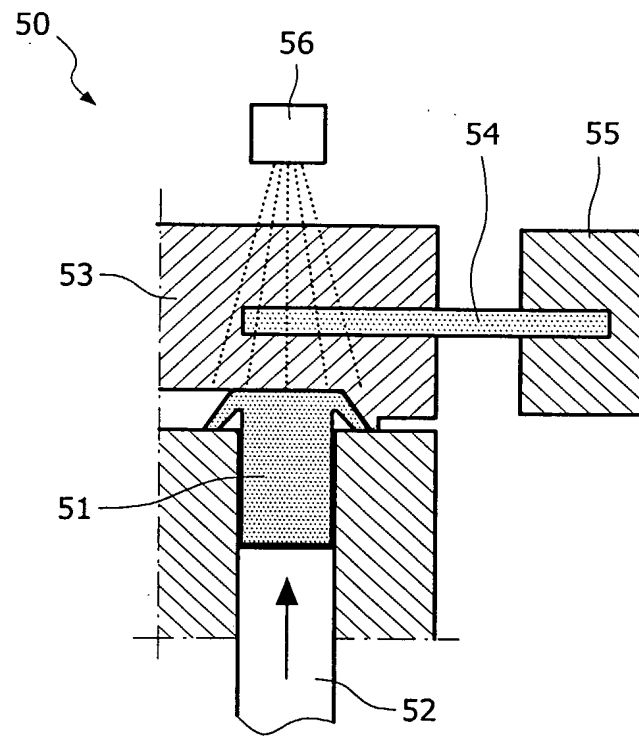


FIG. 5

INTERNATIONAL SEARCH REPORT

PCT/NL2005/000421

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 B29C45/02 B29C45/73 H01L21/56

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B29C H01L

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	PATENT ABSTRACTS OF JAPAN vol. 012, no. 448 (M-768), 24 November 1988 (1988-11-24) -& JP 63 179719 A (MITSUBISHI ELECTRIC CORP), 23 July 1988 (1988-07-23) abstract	1-6, 9-14
Y	-& DATABASE WPI Section Ch, Week 198835 Derwent Publications Ltd., London, GB; Class A32, AN 1988-246653 XP002343032 & JP 63 179719 A (MITSUBISHI HEAVY IND CO LTD) 23 July 1988 (1988-07-23) abstract ----- -/--	7, 8, 15, 16

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents:

A document defining the general state of the art which is not considered to be of particular relevance

E earlier document but published on or after the international filing date

L document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

O document referring to an oral disclosure, use, exhibition or other means

P document published prior to the international filing date but later than the priority date claimed

T later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

X document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

Y document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

& document member of the same patent family

Date of the actual completion of the international search

25 August 2005

Date of mailing of the international search report

12/09/2005

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Alink, M

INTERNATIONAL SEARCH REPORT

PC I / NL2005/000421

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	<p>PATENT ABSTRACTS OF JAPAN vol. 010, no. 301 (M-525), 14 October 1986 (1986-10-14) -& JP 61 114824 A (HITACHI LTD), 2 June 1986 (1986-06-02) abstract -& DATABASE WPI Section Ch, Week 198628 Derwent Publications Ltd., London, GB; Class A32, AN 1986-180487 XP002343033 & JP 61 114824 A (HITACHI LTD) 2 June 1986 (1986-06-02) abstract</p>	1-6,9-14
X	<p>----- PATENT ABSTRACTS OF JAPAN vol. 011, no. 225 (M-609), 22 July 1987 (1987-07-22) -& JP 62 039215 A (MITSUBISHI ELECTRIC CORP), 20 February 1987 (1987-02-20) abstract -& DATABASE WPI Section Ch, Week 198713 Derwent Publications Ltd., London, GB; Class A32, AN 1987-089795 XP002316588 & JP 62 039215 A (MITSUBISHI DENKI KK) 20 February 1987 (1987-02-20) abstract</p>	9
A	<p>----- US 3 859 024 A (PASCH ET AL) 7 January 1975 (1975-01-07) column 6, line 10 - line 54</p>	1,9,10
A	<p>----- PATENT ABSTRACTS OF JAPAN vol. 004, no. 171 (M-044), 26 November 1980 (1980-11-26) & JP 55 121044 A (INOUE MTP CO LTD), 17 September 1980 (1980-09-17) abstract</p>	1,9,10
A	<p>----- DE 83 20 638 U1 (PURMA INDUSTRIEANLAGEN GMBH, 7100 HEILBRONN, DE) 1 December 1983 (1983-12-01) figures 1,2</p>	1,9,10
A	<p>----- PATENT ABSTRACTS OF JAPAN vol. 006, no. 240 (M-174), 27 November 1982 (1982-11-27) -& JP 57 137130 A (MITSUBISHI DENKI KK), 24 August 1982 (1982-08-24) abstract</p> <p style="text-align: center;">----- -/--</p>	3

INTERNATIONAL SEARCH REPORT

PCT/NL2005/000421

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	DE 93 05 714 U1 (KLOECKNER FERROMATIK DE SMA GMBH, 7831 MALTERDINGEN, DE) 17 June 1993 (1993-06-17) page 15 - page 16	1,9,10
A	PATENT ABSTRACTS OF JAPAN vol. 2000, no. 05, 14 September 2000 (2000-09-14) -& JP 2000 052390 A (KOMATSU LTD), 22 February 2000 (2000-02-22) abstract -& DATABASE WPI Section Ch, Week 200020 Derwent Publications Ltd., London, GB; Class A32, AN 2000-232182 XP002316589 & JP 2000 052390 A (KOMATSU SEISAKUSHO KK) 22 February 2000 (2000-02-22) abstract	4
Y	US 4 577 078 A (NODA ET AL) 18 March 1986 (1986-03-18) abstract claim 1	7,8,15
Y	PATENT ABSTRACTS OF JAPAN vol. 010, no. 246 (M-510), 23 August 1986 (1986-08-23) & JP 61 076332 A (HITACHI LTD), 18 April 1986 (1986-04-18) abstract -& DATABASE WPI Section Ch, Week 198622 Derwent Publications Ltd., London, GB; Class A32, AN 1986-140740 XP002316590 & JP 61 076332 A (HITACHI LTD) 18 April 1986 (1986-04-18) abstract	7,8,15
A	EP 0 562 556 A (FUJI ELECTRIC CO., LTD) 29 September 1993 (1993-09-29) abstract	1
A	US 4 927 580 A (NASU ET AL) 22 May 1990 (1990-05-22) column 3, line 58 - column 4, line 6	1
Y	PATENT ABSTRACTS OF JAPAN vol. 008, no. 198 (E-265), 11 September 1984 (1984-09-11) -& JP 59 086229 A (TOSHIBA KK), 18 May 1984 (1984-05-18) abstract -/--	16

INTERNATIONAL SEARCH REPORT

PCT/NL2005/000421

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	<p>-& DATABASE WPI Section Ch, Week 198507 Derwent Publications Ltd., London, GB; Class A85, AN 1985-040274 XP002343034 & JP 59 086229 A (TOSHIBA KK) 18 May 1984 (1984-05-18) abstract</p> <p>-----</p>	1,9
	<p>"TRANSFER-MOLDING MIT KALTKANAL TRANSFER MOULDING WITH COLD RUNNER" PLASTVERARBEITER, ZECHNER UND HUETHIG VERLAG GMBH. SPEYER/RHEIN, DE, vol. 45, no. 8, 1 August 1994 (1994-08-01), page 92, XP000486426 ISSN: 0032-1338 the whole document</p> <p>-----</p>	

INTERNATIONAL SEARCH REPORT

Information on patent family members

PCT/NL2005/000421

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
JP 63179719	A	23-07-1988	NONE	
JP 61114824	A	02-06-1986	NONE	
JP 62039215	A	20-02-1987	JP 1742472 C JP 4031285 B	15-03-1993 26-05-1992
US 3859024	A	07-01-1975	DE 2164219 A1 AR 198496 A1 AT 349736 B AT 1087672 A AU 465280 B2 AU 4970172 A BE 793000 A1 BG 29429 A3 CA 990030 A1 CA 994065 A2 CH 566205 A5 CS 223857 B2 DD 102634 A5 FI 56643 B FI 763479 A ,B, FR 2164754 A1 GB 1409108 A GB 1409107 A HK 58880 A HK 58980 A IT 984658 B JP 48072258 A JP 55038260 B JP 1316423 C JP 54000061 A JP 60039533 B LU 66723 A1 MX 147916 A NL 7216665 A ,B, NO 764381 A PL 89688 B1 SE 403352 B SE 417172 B SE 7600610 A SE 421113 B SE 7901786 A US 3961014 A US 4213814 A YU 2279 A1 YU 313372 A	05-07-1973 28-06-1974 25-04-1979 15-09-1978 25-09-1975 06-06-1974 19-06-1973 14-11-1980 01-06-1976 03-08-1976 15-09-1975 25-11-1983 20-12-1973 30-11-1979 02-12-1976 03-08-1973 08-10-1975 08-10-1975 24-10-1980 24-10-1980 20-11-1974 29-09-1973 03-10-1980 15-05-1986 05-01-1979 06-09-1985 22-02-1973 01-02-1983 26-06-1973 26-06-1973 31-12-1976 14-08-1978 02-03-1981 21-01-1976 30-11-1981 27-02-1979 01-06-1976 22-07-1980 31-10-1982 30-06-1981
JP 55121044	A	17-09-1980	NONE	
DE 8320638	U1	01-12-1983	NONE	
JP 57137130	A	24-08-1982	NONE	
DE 9305714	U1	17-06-1993	NONE	
JP 2000052390	A	22-02-2000	NONE	

INTERNATIONAL SEARCH REPORT

Information on patent family members

PCT/NL2005/000421

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
US 4577078	A	18-03-1986	JP 1507611 C	26-07-1989
			JP 59220932 A	12-12-1984
			JP 63055861 B	04-11-1988
			JP 1507612 C	26-07-1989
			JP 59220933 A	12-12-1984
			JP 63055862 B	04-11-1988
			DE 3420280 A1	06-12-1984
			GB 2141909 A , B	03-01-1985
JP 61076332	A	18-04-1986	JP 1636709 C	31-01-1992
			JP 2060500 B	17-12-1990
EP 0562556	A	29-09-1993	JP 5326599 A	10-12-1993
			EP 0562556 A1	29-09-1993
			US 5368805 A	29-11-1994
US 4927580	A	22-05-1990	JP 1157610 A	20-06-1989
			KR 9400430 B1	20-01-1994
JP 59086229	A	18-05-1984	NONE	